

PRODUCT DESCRIPTION

MXBON® 13565 is designed for the sealing and locking of metal fittings and pipes. The product is a single component anaerobic, thixotropic, acrylic based product. The product cures when confined in the absence of air between close fitting metal surfaces and prevents leakage and loosening from vibration and shock.

Technology	Acrylic
Chemical Type	Methacrylate ester
Appearance (uncured)	White to off-white paste
Components	One component – requires no mixing
Viscosity	High, thixotropic
Cure	Anaerobic
Secondary Cure	Activator
Application	Thread sealing
Strength	Low

NSF International

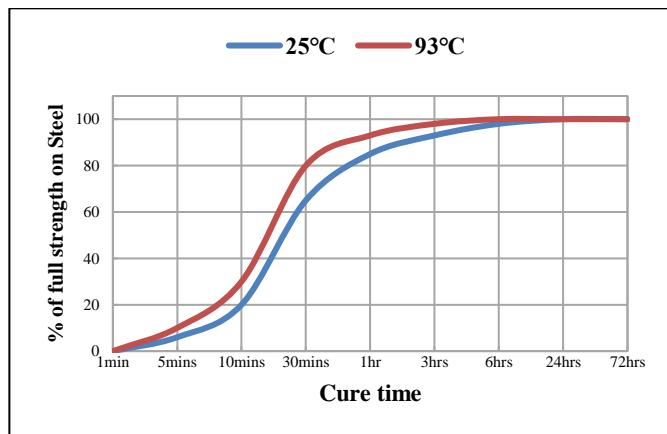
Registered to NSF Category S6 for use as a thread locking where there is no possibility of food contact in and around food processing areas. Note: This is a regional approval. Please contact your local Technical Service Center for more information and clarification.

TYPICAL PROPERTIES OF UNCURED MATERIAL

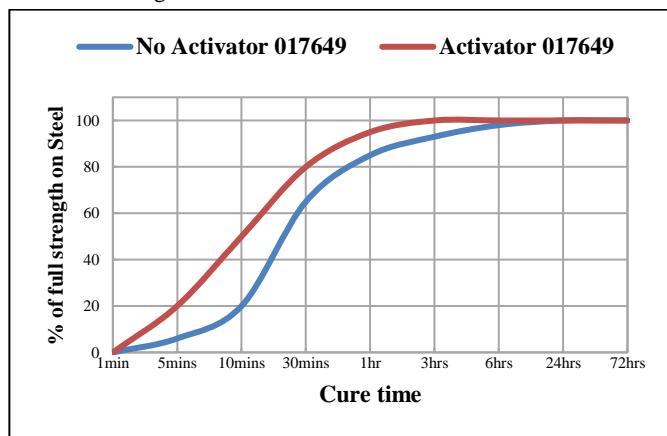
Specific Gravity @ 25 °C	1.1
Flash Point -	See SDS
Viscosity, Brookfield - RVT, 25 °C, mPa·s (cP)	
Spindle 7, 2 rpm	175,000 to 525,000
Shelf life	24 months unopened when stored at 8 to 24°C

TYPICAL CURING PERFORMANCE**Cure Speed vs. Temperature**

The rate of cure will depend on the temperature. The graph below shows the breakaway strength developed with time at different temperatures on M10 steel nuts and bolts and tested according to ISO 10964.

**Cure Speed vs. Activator**

Where cure speed is unacceptably long, or large gaps are present, applying activator to the surface will improve cure speed. The graph below shows the breakaway strength developed with time on M10 zinc dichromate steel nuts and bolts using Activator 017649 and tested according to ISO 10964.

**TYPICAL PERFORMANCE OF CURED MATERIAL****Adhesive Properties - Torque**

Cured for 24 hrs @ 25 °C

Breakaway Torque, ISO 10964, Unseated:

Bonding Identical Substrate	N.m	lb.in.
M10 steel nuts and bolts	3	26

Cured for 24 hrs @ 93 °C, tested @ 25 °C

Breakaway Torque, ISO 10964, Unseated:

Bonding Identical Substrate	N.m	lb.in.
M10 steel nuts and bolts	4	35

Adhesive Properties - Shear Strength

After 24 hours @ 25 °C

Compressive Shear Strength, ISO 10123:

Steel pins and collars	N/mm ²	psi
Steel pins and collars	1.4	203

TYPICAL ENVIRONMENTAL RESISTANCE

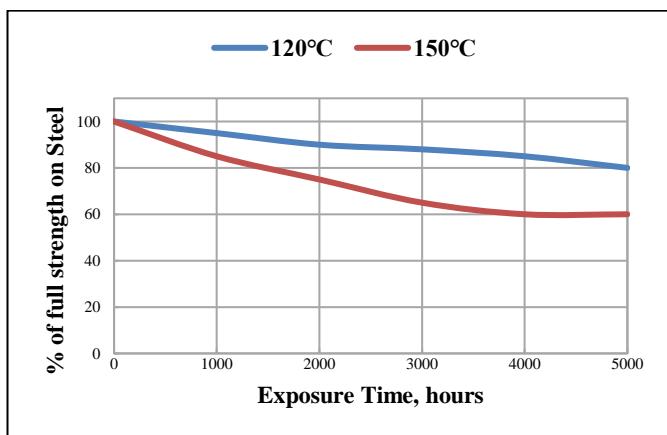
Cured for 1 week @ 25 °C

Breakloose Torque, ISO 10964, Pre-torque to 5 N.m

M10 steel nuts and bolts

Heat Aging

Aged at temperature indicated and tested @ 25 °C

**Chemical/Solvent Resistance**

Aged under conditions indicated and tested @ 25 °C

Environment	% of initial strength	
	°C	720 h
Unleaded Petrol	25	95
Water/ethylene glycol 50/50	87	100
IPA	25	95
Acetone	25	95

GENERAL INFORMATION

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be used with chlorine or other strong oxidizing materials. Where washing systems are used to clean the surfaces before bonding, it is important to check the compatibility of the washing solution with the adhesive. In some cases, these solutions can affect the cure and performance of the adhesive. This product is not recommended for use on certain plastics. Users are recommended to confirm compatibility of the product with such substrates.

Storage & Handling precaution

Keep adhesive in a cool and dry place. The storage temperature is recommended at 8 °C to 24 °C. For details, consult the Safety Data Sheet, (SDS). Shelf life is two years from the date of manufacture in the original container under the optimal conditions.

1. Avoid contact with skin and eyes.
2. If contact with skin, rinse with water.
3. If adhesive gets into eye, keep eye open and rinse with water thoroughly. Seek medical attention immediately.
4. Keep the material out of children's reach.

Directions for use

For assembly

1. The substrate surfaces must be clean and free of grease.
2. Shake the product thoroughly before use.
3. If the cure speed is too slow, consider using activator.
4. Apply several drops to the nut & bolt.
5. Assemble and tighten as required.
6. To prevent the clogging of the bottle nozzle, do not let the tip touch the metal surfaces during application.

For disassembly & cleanup

1. Use localized heat (250 °C) to nut and bolt, disassemble while hot.
2. Use a wire brush to clean the charred product.

Note

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